

AMENDMENTS TO THE CLAIMS:

Please amend dependent claim 18, as indicated in the following listing of claims, which replaces all prior versions and listings of claims in the application:

1. (Original) A multi-stage tube forging method for disproportionally enlarging an end section of an aluminum alloy tube of a bicycle frame part, comprising the steps of:
 - (a) drawing the aluminum alloy tube to form a thin section and a thick end section extending from the thin section, wherein the thin section has a wall thickness thinner than that of the thick end section;
 - (b) radially and proportionally enlarging the cross-section of the thick end section of the aluminum alloy tube by forging the aluminum alloy tube in a first die using a first mandrel in such a manner that the wall thickness of the thick end section after being enlarged is substantially the same as that of the thin section; and
 - (c) disproportionally varying the cross-section of the thick end section of the aluminum alloy tube by forging the aluminum alloy tube obtained in step (b) in a second die using a second mandrel.
2. (Original) The multi-stage tube forging method of Claim 1, wherein the perimeter of an end edge of the thick end section of the aluminum alloy tube obtained after step (c) is substantially equal to that of the end edge of the thick

end section of the aluminum alloy tube obtained after step (b) and before step (c).

3. (Original) The multi-stage tube forging method of Claim 1, wherein the aluminum alloy tube is cleaned and subsequently immersed in a lubricant medium before the drawing operation.
4. (Original) The multi-stage tube forging method of Claim 1, wherein the aluminum alloy tube is partially annealed prior to the drawing operation.
5. (Original) The multi-stage tube forging method of Claim 4, wherein the partial annealing operation is conducted at a temperature ranging from 350°C to 380°C for 2 to 3 hours.
6. (Previously Presented) A multi-stage tube forging method for disproportionally enlarging an end section of an aluminum alloy tube of a bicycle frame part, comprising:
 - (a) drawing the aluminum alloy tube to form a thin section and a thick end section extending from the thin section, wherein the thin section has a wall thickness thinner than that of the thick end section;
 - (b) radially and proportionally enlarging the cross-section of the thick end section of the aluminum alloy tube by forging the aluminum alloy tube in a first die using a first mandrel;

(c) disproportionally varying the cross-section of the thick end section of the aluminum alloy tube by forging the aluminum alloy tube obtained in step (b) in a second die using a second mandrel; and

wherein the aluminum alloy tube is completely annealed prior to the enlarging operation of step (b).

7. (Original) The multi-stage tube forging method of Claim 6, wherein the complete annealing operation is conducted at a temperature ranging from 400°C to 420°C for 2 to 3 hours.
8. (Previously Presented) The method of claim 1, wherein the step of radially and proportionally enlarging the cross-section of the thick end section of the aluminum alloy tube includes forging the thickness of the thick end section to be substantially the same as the thickness of the thin section.
9. (Previously Presented) A method for making a tube for a frame part comprising:

drawing a tube having a first section with a thickness and a second section; and

radially and proportionally heat forging the second section of the tube from a first shape, which has a thickness that is greater than the thickness of the first section, to a second shape, which has a thickness that is less than the thickness of the first shape.

10. (Previously Presented) The method of claim 9, wherein the step of drawing includes shaping an aluminum alloy material.
11. (Previously Presented) The method of claim 9, wherein the step of drawing a tube includes partial annealing of the tube.
12. (Previously Presented) The method of claim 9, wherein the step of drawing a tube includes complete annealing of the tube.
13. (Previously Presented) The method of claim 9, wherein the step of radially and proportionally forging includes shaping the thickness of the thick end section to be substantially the same as the thickness of the thin section.
14. (Previously Presented) The method of claim 9, wherein the step of radially and proportionally forging includes shaping the second section of the tube about a die using a mandrel.
15. (Previously Presented) The method of claim 9, further comprising forging the second shape of the second section of the tube to a third shape, which has a first end portion that is disproportionally varied relative to a second end portion.

16. (Previously Presented) The method of claim 15, wherein the step of forging the second shape of the second section of the tube to a third shape includes heat forging the first end portion into a substantially rectangular shape and heat forging the second end portion into a substantially circular shape.
17. (Previously Presented) The method of claim 15, wherein the step of forging the second section of the tube includes heat shaping the second section about a die using a mandrel.
18. (Currently Amended) The method of claim 9, further comprising forming a surface texture having at least one wrinkle on ~~the second shape of~~ the second section of the tube.